

ABSTRACT

A method and apparatus for calendering paper or board in the manufacture of coated grades of paper or board. At least one of the surfaces of an uncoated base material web is calendered, at least one layer of coating mix being applied onto said surface, and at least the coated surface of the base web is calendered again. The uncoated surface of the base web is calendered by means of a shoe calender having a nip length of at least 50 mm, and the coated surface of the base web is calendered by means of a calender having a nip length of 50 mm at the most.